Work Orac December-19-12				*946	570*							Page 1	İ
Item ID: Revision ID:	D2360			Accept	*N900	040	100)*	Setup	Start Stop	*N!	S1*	
Item Name:	Litter Tie Dow	n Assembly								этор	*N:	S2*	
Start Date:	1/15/13	Start Qty: 6.00	*6*	9	Cust Item I	D:							,
Required Date:	1/15/13	Req'd Qty: 6.00	*6*		Customer:								
Reference:										~			
Approvals:	Process Pla	n: <i>fl</i>	Date: 12-20-12	L Tooling:	Da Da	ate:]		Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop ·	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr											
D2341	Rev	F											
D2360	Rev	D											
100				0.00									
100		BAND SAW						P					
Bandsaw		Memo		0.00	JLB-	01-07	, -	6					
Jeaspa Bandsaw		Cut blanks	: 12.65" Long										
110				0.00				, ,		,			
110		HAAS CNC VERTICA	L MACHINING #1		JAUD.a	13-01	-09	6		Ø			_
HAAS 1		Memo	t.	0.00	4 7	,	- ,			,-			
HAAS CNC vertica	al machine #1	Machine a 2-Deburr	s per Folio D2341 and Dwg	D2341									

												DQA:	Date:	•
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
						T	DISDOSITION				A CAUNIST DE			
Nork Ord	er:					1	DISPOSITION				AGAINST DE	PAKIMENI	PROCESS	
Part l	No.	-					Rework Scrap Use-as-is		ľ	Skid-tube Machining Incoming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.						Work Order Update			Large Fab	Composite	, Recyston	Supplier	J Guiei
Root					Desc	rip	tion of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved														
							F	AUL	T CATE	GORY				•
Landi	ng (Gear					General					_		
		Bending Centre No Cracks Crushed/0		ntric to (D/S		Bend BOM/Route Broken/Damaged Burrs		1	re on Incomplete ions Incomplete/	Unclear	Ovalized Over/Under Part Incorre Part Lost/M	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Cuffs Heat Trea	t			_	Contamination Countersink		Mainte Mislabe			Part Moved Positioned V	Vrong	
		Inspection	Strip in	Tube		\neg	Cut Too Short		Misread	t		Power Loss/	Surge	Other
	\vdash	Ripples in	-		F	ヿ	Drill Holes		Offset		_		<u>. </u>	
		Torque W		xtrusion	,	_	Drawing		Out of 0	Calibration				
	П	Turning Se			F	_	Finish		1	enuence				

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 94670 Page 2 December-19-12 2:23:47 PM D2360 Accept Setup Start Item ID: *N900040100* Revision ID: Litter Tie Down Assembly Item Name: Start Otv: 6.00 **Start Date:** 1/15/13 **Cust Item ID:** Required Date: 1/15/13 Reg'd Otv: 6.00 **Customer:** Reference: Run Start Tooling: Date: Approvals: Process Plan: Date: Stop Date: _____ SPC (Y/N): Date: Reject Reject Insp. Sequence ID/ Tool ID Tool # Plan Operation Set Up/ Accept Work Center ID Code Qty Otv Number Stamp Description **Run Hours** OC2- Inspect parts off machine FAI/FAIB 0.00 120 13-01-09 *120* QC 0.00 Memo **Quality Control** and 13/01/10 OC8- Inspect parts - second check 0.00 130 *120* OC 0.00 Memo Quality Control Chemical Conversion Coat per OSI005 4.1 140 0.00 MB-110

0.00

Memo

140 HandFinish

Hand Finishing

1	NCR:	Yes /	No	WOF

NCR: Y	'es	/ No				WORK ORDER NON-O	CON	IFORN	MANCE / UPD	PATE	QA Closed:	Date:	•
Nork Orde	er:		*			DISPOSITION				AGAINST DE	<u> </u>		
Part N	- lo					Rework Scrap		ľ	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	lo					Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/stor	e/Packaging Supplier	Other
Root						ption of work order update	ł	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chi	ief Eng	Descri	iption	Date	Verification	QC Inspector
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etup													
ther		:											
rocess													
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Landir						General				<u></u>	1	_	, ,
	-	Bending	_			Bend	$\boldsymbol{\vdash}$	Grain			Ovalized	. —	Pressure/Forced
	_	Centre No	ot Concer	ntric to (o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under		Temperature/Cure
	$\overline{}$	Cracks			.	Broken/Damaged	\vdash		on Incomplete		Part Incorred		Weld
		Crushed/0	Crimped.		· -	Burrs			ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
j		Cuffs			<u> </u>	Contamination	\vdash	Mainte			Part Moved		
ļ	\dashv	Heat Trea		TL =	 	Countersink	-	Mislabe		·	Positioned V	_	Jothan
ŀ	_	Inspection	•	rube	-	Cut Too Short	-	Misread	I	L	Power Loss/	ourge	Other
ļ	-	Ripples in			_	Drill Holes	-	Offset	`alibeatian				
}	_	Torque W		atrusioi	'' -	Drawing	-		Calibration				
1	1	Turning Se	equence		ł	Finish	1 1	Out of S	iequence				

Date: +

DQA:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde December-19-12				*946	37N*						Page 3
Revision ID:	D2360 Litter Tie Dov	wn Assembly	·	Accept	*N900	<u>040</u>	100) * s	Setup Sta	1.71	S1* S2*
Start Date: Required Date: Reference:	1/15/13 1/15/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					
Approvals:		an:	Date:	_		ate:		·F	Run Sta Sto	m	R1* R2*
Sequence ID/ Work Center II 150 *150* Powdercoat Powder Coating)	Operation Description White Gloss(Ref.4.3.5.1 Memo START TIM OVEN TEM FINISH TIM	ME: <u>/:05.</u> MPERATURE: 3	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	•
*160 *160* QC Quality Control		QC3- Inspect Part Finish Memo	1	0.00				Ex.			J3/w/)
170 *170* Small Fab	C	Small Fab Memo Assemble a	s per dwg D2360 お、よくしく	0.00				6x			J\13/21/
			(3.01.15				-				

NCR: Y	\cdot													
												QA Closed:	Date:	
Work Orde	r: _						DISPOSITION				,	EPARTMENT,		
Part N	o						Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other
NCR N	o						Work Order Update			Large Fab	Composite	<u> </u>	Supplier	
Root					Des	crip	otion of work order update	1:	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		С	r Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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	E	Bending					Bend		Grain			Ovalized		Pressure/Forced
Ī	\Box	Centre No	t Concer	tric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	\Box	Cracks					Broken/Damaged		Inspecti	on Incomplete	Γ	Part Incorre	ct	Weld
Γ		Crushed/C	rimped.				Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
ſ		Cuffs					Contamination		Mainte	enance		Part Moved		_
Ī	\neg	Heat Treat	t		,		Countersink		Mislabe	eled	Γ	Positioned V	Vrong	
ľ	1	nspection	Strip in	Tube			Cut Too Short	П	Misread	· ·	T T	Power Loss/	Surge	Other
ľ	\neg	Ripples in					Drill Holes		Offset		_			
	┨┚	Γorque Wa	aves in E	xtrusio	n		Drawing		Out of (Calibration		***************************************	-	
<u> </u>	_	Γurning Se					Finish		Out of 9	Sequence				
	_	Nave/Twi	-	e	:		Folio	-	l .	Dimensions				

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order December-19-12				*946	370*				Page 4
Item ID: E	D2360 Litter Tie Dow			Accept	*N900040	100*	Set	up Start Stop	*NS1* *NS2*
Start Date: 1 Required Date: 1 Reference:	/15/13 /15/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:	_	D	Stout	
	Process Pla	n:		Tooling: SPC (Y/N):	Date: Date:		Ru	n Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID 180 *180* QC Quality Control 190 *100* Packaging Packaging		Operation Description QC5- Inspect part comple Memo Identify as per dwg & Ste			Tool ID Tool #				Reject Insp. Number Stamp
200 *200* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00				[3]:	2/19 AD MF 13-2-E

NCR:	. The state of th													
											QA Closed:	Date:		
Work Orde	er:					DISPOSITION	_			AGAINST DE	PARTMENT	PROCESS		
Part I	10.					Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality	
NCR I	١٥٠					Use-as-is Work Order Update			Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other	
Root					Descr	ription of work order update	Т	nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
oc/Data										-		•		
quip/Tooling														
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laterial														
etup												·		
ther														
rocess														
upplier														
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napproved														
							AUL	T CATE	GORY					
Landi	ng (Sear				General					-	_	·	
		Bending			_	Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks			<u> </u>	Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld	
		Crushed/C	Crimped.		L	Burrs	•	Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance		Part Moved			
		Heat Treat	t			Countersink		Mislabe	led		Positioned V	Vrong	_	
		Inspection	Strip in	Tube	Γ	Cut Too Short		Misread	1		Power Loss/	Surge	Other	
		Ripples in	Bend			Drill Holes		Offset						
;		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration					
		Turning Se	equence			Finish		Out of S	equence					
•		Wave/Twi	ist in Tub	oe		Folio		Outside	Dimensions					

DQA:

Date: •

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Picklist'Print

December-19-12 2:23:46 PM

Work Order ID:

94670

Parent Item:

D2360

Parent Item Name:

Litter Tie Down Assembly

Start Date: 1/15/13

Required Date: 1/15/13

Start Qty: 6.00

Required Qty: 6.00

i ai cite item i ame.	Bitter Tie Bown At	,							urt Qty. 0.00		required	Q.1,1 0.00	
Comments:	IPP rev H 07.06.13	2 ecn 825 EC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R18 Screw		Purchased	No			170	Each	593.0000	1	⁶ ح	1/3	102	/19
				Location		Loc Qty	Lo	oc Code			,		
				FP001		93							
				452	23	93	1				M10	11158	3
				ST346		500	1				19110		
					8079	400						(la	
				110	0099	100					.01	. /	, ,
AN960JD10	NAS1149D0363J	Purchased	No			170	Each	0.0000	2	12		3 /2	/./
Washer	40	1122378	120	< ,				0.0000			ファック	7/42	-//-
-AN960JD10L	NAS1149D0332J	Purchased	No			170	Each	0.0000	8	48	(S)	3 /2	/15
Washer	4	M12297	3 (4	8×)		170	Cook	0.0000	2		101		///
D2002-015 Knob		Manufactured	NO			170	B95	6556	(122)	12	[-//	13/6	> //4
D2345		M C . 1	No			170	Each	21.0000			1//	(<i>'</i>
Lock Channel		Manufactured	140			170	Lacii	21.0000		6		13/0	2//
Book Chainer				<u>Location</u>		Loc Qty	L	oc Code			7	7	7
				GA		21				_ /	多		
					349	2				6	12.		,
D2366		Manufactured	No			170	Each	22.0000	2	12	IJA	- /	
Lock Handle									*		13/	3/00	//4
				Location		Loc Qty	<u>L</u>	oc Code				′ /	
				ST009		22	2						
					351		3						
				89	161	19)		10	2 ^	202	-	

												DQA:	Date	:
NCR:	'es	/ No				1	WORK ORDER NON-C	O	NFORN	MANCE / UPI	DATE			•
						_						QA Closed:	Date	:
Nork Orde	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	-						Rework Scrap Use-as-is	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other					
NCR N	۱٥						Work Order Update			Large Fab	Composite	_	Supplier	_
Root	٦	-			Desci	ripti	on of work order update	1	nitial	Act	tion	Sign &	,	
Cause		Date	Step	Qty			Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved											•			
				*			F	AUL	T CATE	GORY		· · · · · · · · · · · · · · · · · · ·		
Landii	ng G	iear	·		.,,		General							
		g Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				BI BI CC CC	end OM/Route roken/Damaged urrs ontamination ountersink ut Too Short rill Holes		Instructi Mainte Mislabe Misread Offset	or Incomplete ons Incomplete/I nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		<u>.</u>				—1	rawing	<u>_</u>	1	alibration				
	- 1	Turning Se	eauence	•	1	Fi	nish	1	Out of S	ecuence				

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-19-12 2:23:47 PM

Work Order ID:	94670								
Parent Item:	D2360						Start	Date: 1/15/13	Required Date: 1/15/13
Parent Item Name:	Litter Tie Down Ass	sembly					Star	t Qty: 6.00	Required Qty: 6.00
D2367 Handle Knob		Manufactured	No		170	Each	13.0000	1	6 13/02/14
				Location	Loc Oty		Loc Code		
				ST009	13				
				83541	1				<u> </u>
				89083	12			&	- 0/ / /
D2372 Quick Release		Manufactured	No		170	Each	5.0000	2	12 /3/02/11
				<u>Location</u>	Loc Qty		Loc Code		100-22 (11
,				GA	5				1 376232
				80274	2				B951776
				86001	3				
D2373		Manufactured	No		170	Each	19.0000	1	
Spring		ivianuiactured							13/02/14
-FG				Location	Loc Qty		Loc Code		
				ST009	19				
				86352	19			6	
D2444		Manufactured	No		170	Each	7.0000	1	
Pip Pin Assembly		Manufactured						<u> </u>	J3/80/14
				Location	Loc Qty		Loc Code		
				GA	3				B76216 (2
				88498	3				
				ST010	4				1595898(4
				91616	4				
D6201		Manufactured	No		100	f	57.4586	1.054 6.0	5568422
"T" Extrusion		ivianuiaciuieu							J. B-01-07
LAGUSION				Location	Loc Qty		Loc Code		
							<u>Lot Cout</u>		•
				MAT028 81421	57.45863153 17.4586315			-	<u> </u>
				81421 83987	17.4586315				<u> </u>
		•		89645	20			6.7	

											DQA.	Date.	
NCR:	⁄es	/ No				WORK ORDER NON-O	CONF	ORN	ANCE / UPDA	ATE			
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I						Rework Scrap Use-as-is		į	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.					Work Order Update]		~ —	Composite	,	Supplier	
Root				,	Descr	iption of work order update	Init	tial	Actio	n	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief	f Eng	Descrip	otion	Date	Verification	QC Inspector
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			·		L	F.	AULT	CATE	GORY	2.018		<u> </u>	
Landi	ng (Gear				General		-					
		Bending				Bend	G	rain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Route								re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Damaged							specti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped. Burrs							structi	ions Incomplete/Un	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination	\square M	lainte	nance		Part Moved		
		Heat Trea	t			Countersink	Шм	lislabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short	M	lisread			Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-19-12 2:23:47 PM

Work Order ID:	94670					Stant D	ate: 1/15/13	Required Date: 1/15/13
Parent Item:	D2360						Aty: 6.00	Required Qty: 6.00
Parent Item Name:	Litter Tie Down Assembly						ety: 0.00	Required Qty: 0.00
MS20470AD3-4 Rivet,Universal Head	Purchased	No		170	Each	8,602.0000	1	6 / 13/02/1
		Loca	tion .	Loc Qty		Loc Code		
		GA		270				/
			15541	270			6_	
		ST31	9	8332				
			111477	8332				_ // / /
MS21042L3 Nut	Purchased	No		170	Each	4,778.0000	3	18 \$ 13/02/14
		Loca	ti <u>on</u>	Loc Oty		Loc Code		
		FP00		143				/
			122141	143				_
		GA		458				
			122452	458			_/8	·
		ST31	4	677				
			117885	32				
			119017	55				
			119075	138				<u> </u>
			123265	452			<u>, </u>	
		ST50		3500			·	
		NI.	123900	3500		72.0000		- <i>[]</i> // / /
M\$27039-1-13 Screw	Purchased	No		170	Each	72.0000		6 6 13/02/1
		Loca	<u>tion</u>	Loc Oty		Loc Code		
		GA		16				_/
			119736	16			_6_	<u> </u>
		ST30		56				
			119736	56				- <i>/) /</i> /
, MS27039-1-15	Purchased	No		170	Each	98.0000	2	12 / 12/27/
Screw							C. T. W	
•		Loca	<u>ition</u>	Loc Oty		Loc Code		11. 2097 (2
		ST30)5	98			t	_/M118093 (2
			123352	98			<i>E(</i>)	, t

												DQA:	Date:	τ
NCR:	Yes	/ No					WORK ORDER NON-C		NFORM	//ANCE / UPI	DATE			, "
												QA Closed:	Date:	
Nork Ord	er.						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	,
.vork ora	.						Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part	No.						Scrap		I	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		-					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR	No.						Work Order Update]		Large Fab	Composite]	Supplier	
Root			I		Doc	ri	otion of work order update		nitial		tion	Sign &		
Cause		Date	Step	Qty	Desc		or Non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector
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Landi	ing (Gear			_		General		_					_
	L	Bending					Bend		Grain			Ovalized		Pressure/Forced
	_	Centre No	ot Concer	ntric to (o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld			
	Crushed/Crimped.			Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled			
		Cuffs					Contamination		Mainte			Part Moved		
	<u></u>	Heat Trea			ļ		Countersink		Mislabe	led		Positioned V		, ,
	_	Inspection		Tube	ļ		Cut Too Short		Misread	I		Power Loss/	Surge	Other
	_	Ripples in			1		Drill Holes		Offset					
		Torque W			ր		Drawing		ł	Calibration				
	Turning Sequence			Finish		Out of 9	Sequence							

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-19-12 2:23:47 PM

Work Order ID:

94670

Parent Item:

D2360

Parent Item Name:

Litter Tie Down Assembly

NAS679A3W

Nut

Purchased

No

184.0000

Loc Code

Start Date: 1/15/13

Required Date: 1/15/13

Start Qty: 6.00

Required Qty: 6.00

Loc Qty Location GA 5 5 1463 2409 179

170

Each

											DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		-	•
											QA Closed:	Date:	
Work Ord	er.		•			DISPOSITION			•	AGAINST DE	PARTMENT,	/PROCESS	
Part		•			····	Rework Scrap Use-as-is		f	Skid-tube Machining	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.					Work Order Update		•	Lärge Fab Composite		Supplier		
Root					Descri	ption of work order update		Initial	Ac	ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data			•										
Equip/Tooling													
Operator													
Material					<i>:.</i>	· ·							·
Setup													
Other	Ш				:								
Process							1		i				
Supplier								i					
Training							1						
Unapproved										21.0		·	
						<u></u>	AUI	LT CATE	GORY				
Landi	ng (Sear				General	_				-		· webs
		Bending				Bend		Grain			Ovalized		Pressure/Forced
Centre Not Concentric to O/S		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure				
		Cracks				Broken/Damaged		Inspecti	on incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ior's Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		_
		Heat Trea	at			Countersink		Mislabe	lec		Positioned \	N rong	_
Inspection Strip in Tube		Cut Too Short Misread			Power Loss,	/Surge	Other						

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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DART AEROSPACE LTD	Work Order:	94670
Description: Litter Tie Down Bracket (Locking)	Part Number:	D2341
Inspection Dwg: D2341 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1,751	V			260)
2.75	+/-0.030	2,759	V			. (
Ø0.242	+0.005/-0.001	0.245	✓			
Ø0.191	+0,005/-0.001	0.193	~			C ('
R0.25	+/-0.030	R.O.25	\supset			orc
R0.40	+/-0.030	R0,40	\checkmark			ste
12.50	+/-0.030	12505	✓			31006
11.750	+/-0.010	11.757	/			ι,
11.00	+/-0.030	11.003	V	•		\ (
7.00	+/-0.030	7-008	✓			51e01
6.250	+/-0.010	6.253	V		'9	t 1
5.50	+/-0.030	5506				<u></u> (γ
1.50	+/-0.030	1.508	\			
Q.750	+/-0.010	0.757	~		,	
0.400 ·	+/-0.010	0.394	✓			
1.584	+/-0.010	1.586	/			
2.610	+/-0.010	2.611	V			
0.250	+/-0.010	0.242	\			
0.844	+/-0.010	0.847				
Ø0.250	+/-0.010	0.251	\		-	
0.750	+/-0.010	0759	V			/
3.313	+/-0.010	3313	✓			
4.250	+/-0.010	4-242				
1.250	+/-0.010	1.250	✓			

	(DA)		
Measured by: DFC D.A	Audited by: 14	Prototype Approval:	N/A
Date: 2013-01-09	Date: /3/b///D	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.05.24	New Issue P/O D2360	KJ/JLM	
В	07.07.17	Dwg Rev. updated	KJ/JLM ,A	
С	10.02.02	Dimensions updated	KJ W	N N



DESIG	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	ÆD	APPROVED,	DRAWING NO. PREV. D
 	_	- All	D2360 SHEET 1 OF 2
DATE			TITLE ,SCALE
07.0	6.06		LITTER TIE DOWN ASSEMBLY (LOCKING) MTS
Α		95.02.10	NEW ISSUE
В		95.02.20	RE-DESIGN
С		97.08.27	ADD MS20470AD3-4 RIVET
D		07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)

CX 13/02/14 W10,94670

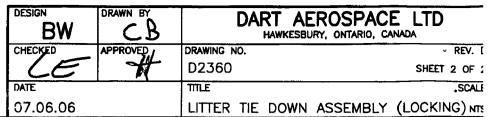
PARTS LIST:

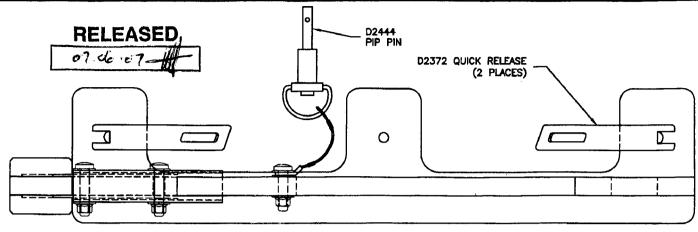
QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT
	· · · · · · · · · · · · · · · · · · ·	

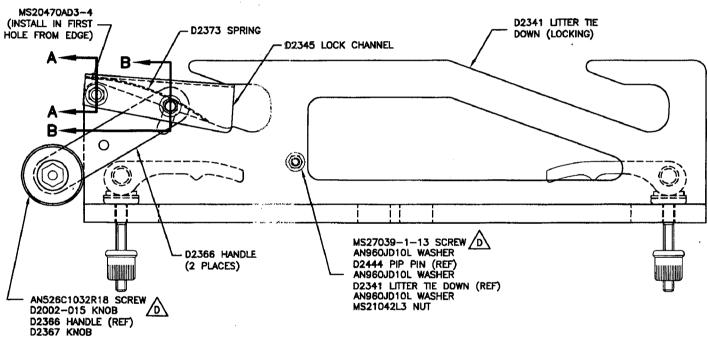


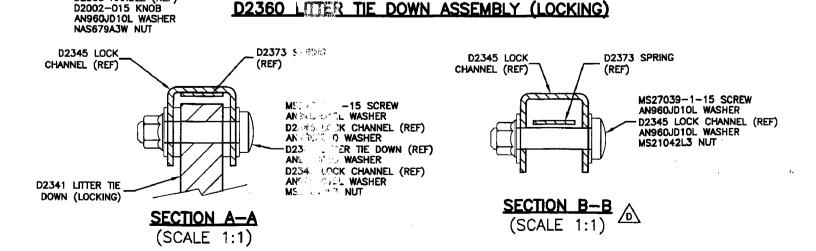


D2366 HANDLE (REF)









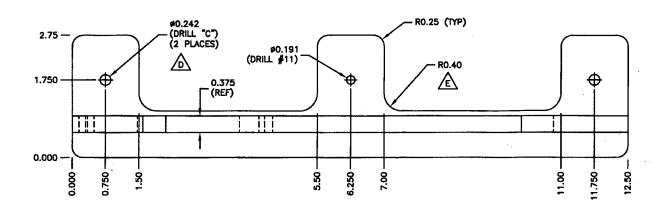
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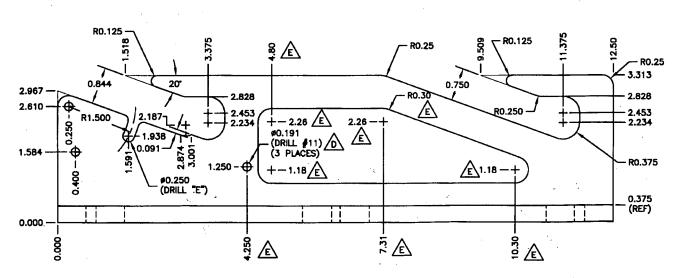


				<u> </u>
	DESIGN BW		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
Ī	CHECK	ED	APPROVED	DRAWING NO. REV. F
I	,	#	T U	D2341 SHEET 1 OF 1
Ī	DATE			TITLE ' SCALE
	07.0	6.07		LITTER TIE DOWN BRACKET (LOCKING) 1:2,
Ĩ	Α		95.01.13	NEW ISSUE
	В		95.02.14	MODIFIED LOCK
	D		95.02.20	CHANGES TO DIAMETERS
	Ε		97.10.01	CHANGES FOR MACHINING
	F		07.06.07	REVISED NOTES; FINISH WAS ANODIZE

RELEASED

94610





- D2341 LITTER TIE DOWN BRACKET (LOCKING)

 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION
 (6061-T6/T651 PER QQ-A-200/8)

 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

 3) BREAK ALL SHAPP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT
 PERMANENT INK MARKER

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